

Work Order ID 60417



Page 1

July 7, 2010 11:13:07 AM

Item ID: D350-589-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Latch Modification

Start Date: 7/07/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CZ Date: 10/7/7 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
INN-D350-589	E								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type label as per PPP D350-589-011 CHG002

S. J. L. 10/7/10

for BG 10/07/10

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10.7.20 (40) SP

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

S. J. L. 10/7/10

(40)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
	Packaging								
	Packaging								
	Memo	0.00							
	Identify and pack for shipping as per QSI 014								
130	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Quality Control								
	Memo	0.00							

10/10/12 3 (4)

10/07/23

MF

10-7-23

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 60417

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F02.08.29 Removed D2587 Plug KJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD10	NAS1149D0363J	Purchased	No			105	Each	0.0000	3	12			
-----------	---------------	-----------	----	--	--	-----	------	--------	---	----	--	--	--



Washer

D2237



Striker Plate

Manufactured No

105

Each

55.0000

3

12

(2x)

BS 5006 10-7-2008

D2583



Latch Bracket

Manufactured No

105

Each

20.0000

3

12

10x

10-7-2008

D2585



Mounting Channel

Manufactured No

105

Each

89.0000

3

12

10

10-7-2008

Location	Loc Qty	Loc Code
ST009	55	
58181	55	
ST018	2	
56527	2	
ST117	18	
59140	18	
ST019	89	
56524	1	
59118	62	
59873	26	

12 M115107

111488 10-7-2008

BS 5006 10-7-2008

10-7-2008

B60425 (2x) 10-7-2008

10-7-2008

12

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 60417

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 4.00

Required Qty: 4.00

D2586

Manufactured No

105

Each

74.0000

3

12



Door Latch

Location

Loc Qty

Loc Code

ST006

74

57917

74

D2587

Manufactured No

105

Each

36.0000

1

4



Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST019

36

56555

36

D2589

Manufactured No

105

Each

210.0000

1

4



Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST019

210

58194

210

MS20470AD4-5

Purchased No

105

Each

1,507.000

6

24



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST309

1442

114761

1442

ST319

65

111916

65

10-7-2010

10-7-2010

10-7-2010
B47183 (14)

10/7/2010 (40)

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Shop Packet Print

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 60417

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

105

Each

2,835.000

3

12



Nut



10.7.20

SP

Location

Loc Qty

Loc Code

ST300

2835

114523

353

114718

482

114784

2000

18

MS27039-1-15

Purchased

No

105

Each

121.0000

3

12



Screw



10.7.20 SP

Location

Loc Qty

Loc Code

ST292

121

114056

21

114718

100

9

3

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Shop Packet Print

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY.

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15/	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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